

Work Order ID 74266

Tuesday, September 27, 2011 1:57:02 PM



Page 1

Item ID:	D3912-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Eyebolt Receiver Assembly				Stop	
Start Date:	9/27/2011	Start Qty:	4.00			
Required Date:	10/4/2011	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	11-09-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3912	B								

100	Pick Kit	0.00							
Packaging		0.00							
Packaging									

11/9/30

110		0.00							
Small Fab		0.00							
Small Fab									

Memo

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

11/11/09/30

120	QC5- Inspect part completeness to step on W/O	0.00							
QC		0.00							
Quality Control									

11/09/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 9/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: ST507

0.00



Packaging

Memo

0.00

Packaging

Pa/9/30 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/4 MF
11-09-30

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 74266

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly




Start Date: 9/27/2011

Required Date: 10/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R  Washer		Purchased	No				Each	227.0000		4			
<div> <div>Location</div> <div>ST297</div> <div>110139</div> <div>116893</div> </div> <div> <div>Loc Qty</div> <div>227</div> <div>27</div> <div>200</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3912-1  Eyebolt		Manufactured	No			100	Each	17.0000	1	4			
<div> <div>Location</div> <div>ST091</div> <div>69593</div> </div> <div> <div>Loc Qty</div> <div>17</div> <div>17</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3912-3  Eyebolt Block		Manufactured	No			100	Each	21.0000	2	8			
<div> <div>Location</div> <div>ST090</div> <div>69539</div> <div>ST091</div> <div>70424</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> <div>19</div> <div>19</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													

4
4
8
11/9/30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:56:59 PM

Page 2

Work Order ID: 74266

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 9/27/2011

Required Date: 10/4/2011

Start Qty: 4.00

Required Qty: 4.00

D3912-5 Manufactured No

100

Each

20.0000

2

8



Eyebolt Plate



Handwritten: 1570866

Location

Loc Qty

Loc Code

ST091

20

73331

20

D3801-1 Manufactured No

Each

9.0000



Hand Retractable Spring Plunger



Handwritten: 4

Location

Loc Qty

Loc Code

ST083

7

69498

7

ST084

2

68379

2

MS20615-4M20 Purchased No

100

Each

160.0000

8



RIVET



Handwritten: 32 9/11/09/30

Location

Loc Qty

Loc Code

GA

160

117071

30

118571

130

MS21209-F615 Purchased No

Each

32.0000



Heli-Coil



Handwritten: 32 9/11/09/30

Location

Loc Qty

Loc Code

ST305

32

108170

21

108244

11

Handwritten: 2 2

Tuesday, September 27, 2011 1:56:59 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

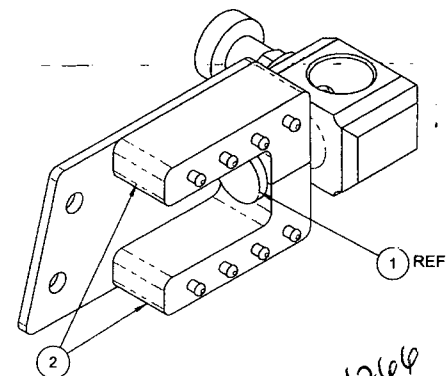
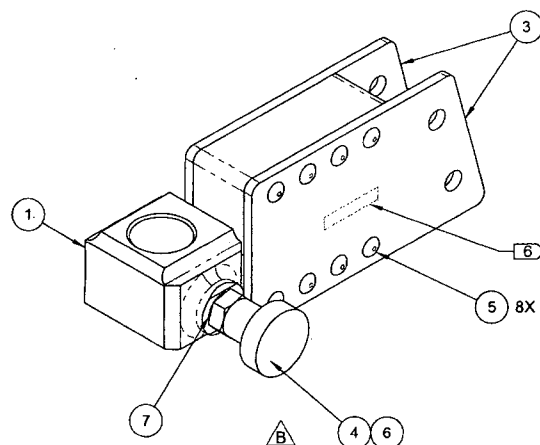
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1/5		
DRAWN	1/1		
CHECKED	1/1		
MFG. APPR.	1/1		
APPROVED	1/1		
DE APPR.	1/1		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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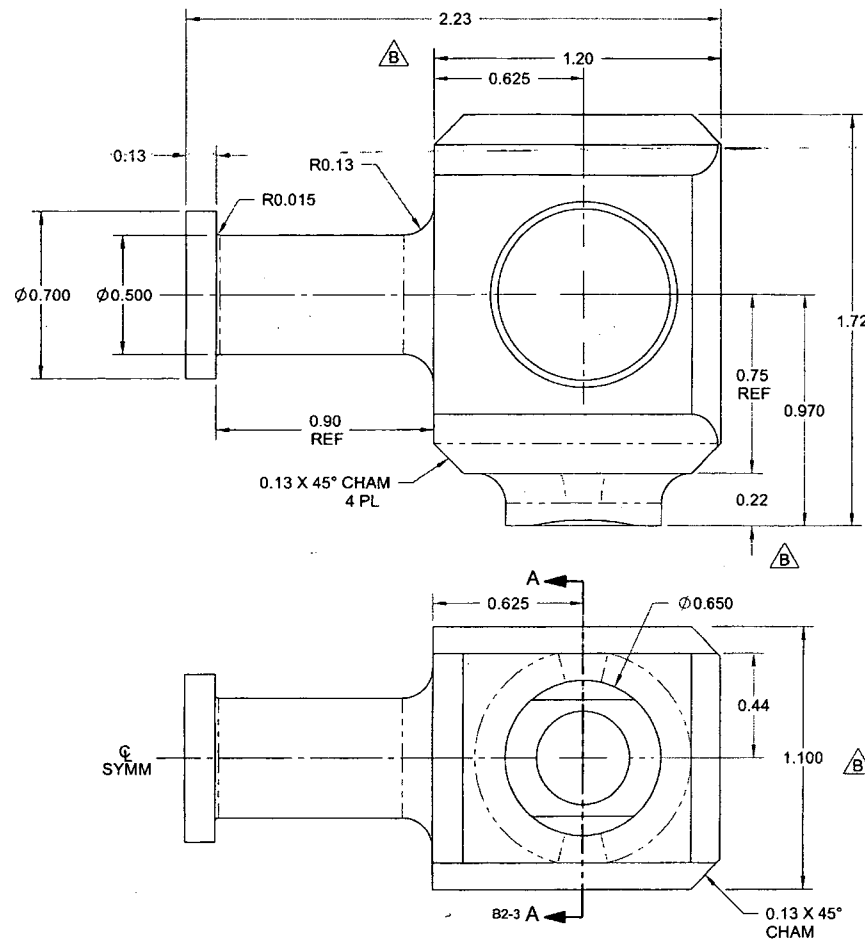
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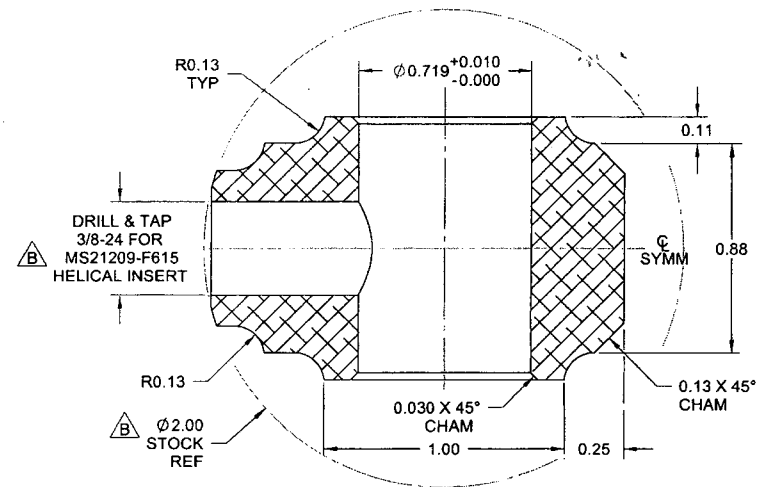
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3912	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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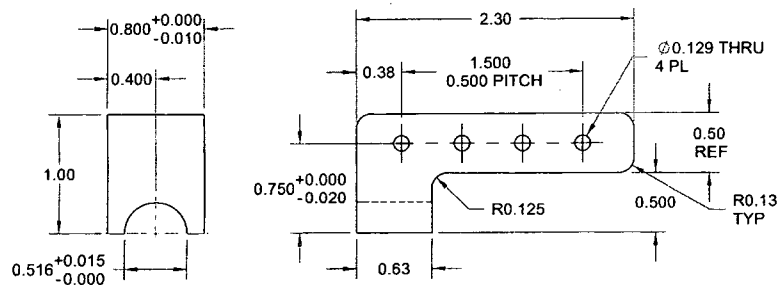
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

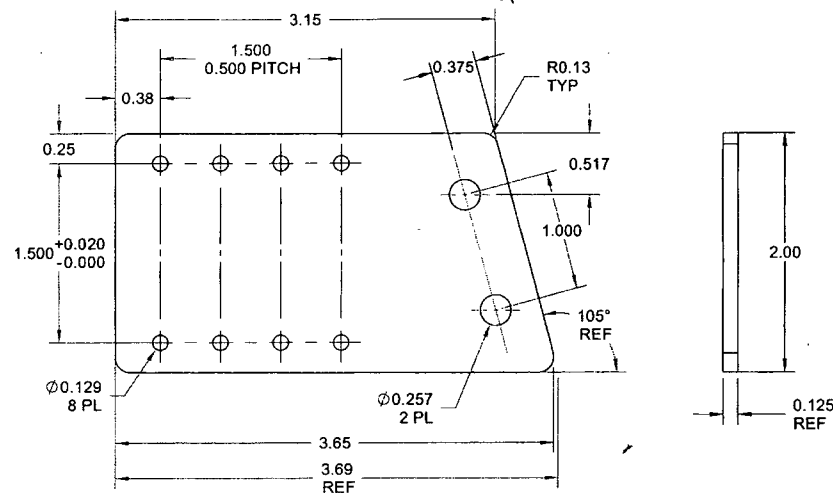
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NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
JMD

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	ALS	D3912	SHEET 3 OF 3
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	EYEBOLT RECEIVER ASSY	NTS
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